

533

DART AEROSPACE LTD.		Work Order :	23882
Description: 204 Skid Tube 'I' Beam		Part Number:	D2597
Drawing Ref: D2597 Rev D		Qty:	3

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg not required</i>	W	05-08-02	3
2	METAL	Cut D2500-3 to length: 84.25" Batch No. <i>R21570</i>	W	05-08-11	3
3	METAL	Use Jig DT8094 to drill pilot holes. Open to 0.625 diameter using a uni-bit.	PM	05-08-11	3
4	QA	Level 5 inspection	2	05-08-11	3
5	METAL	Acid Etch and Alodine per QSI 005 4.1	ML	05-08-17	3
6	EXPEDITING	Close W/O Job Cost			

Rev.	Date	Change	Revised By	Approved By
B	98.01.19	Change Rev of Dwg to C, Add DEO		
C	98.08.05	Updated detail	KY	
D	98.10.15	Eliminated DEO, Changed Dwg Revision	KS	(S)

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector

Date

RELEASED
02/09/17 RF

6	LG	Identify and stock	PM	05-8-25	3
7	AC	Cost / part <i>40.26</i>	Sys	05-08-25	3
8	DC	Close w/o <i>40.26</i> Inspect level 21	Q	05/08/23	3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-08-17	4	Alodine should be before the inspection to ensure Alodine i web is completed properly permanent change				 05-08-17	2 05-08-17	

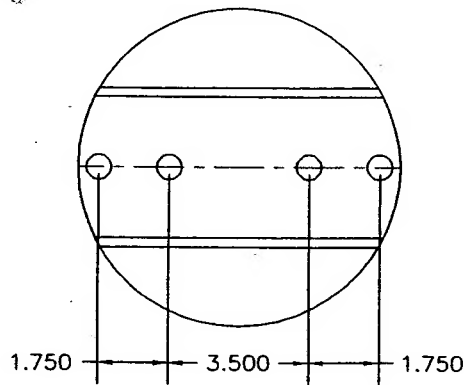
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-11	2	Webs A 1/16 too short, webs were cut on the line.	 05-08-11	Acceptable this time. drill sig was centered to webs to compensate the 1/16" difference	 05-08-11	2 05-08-11	 05-08-11	2 05-08-11

Part No: D2597 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 05/08/23

NOTE: Date & initial all entries

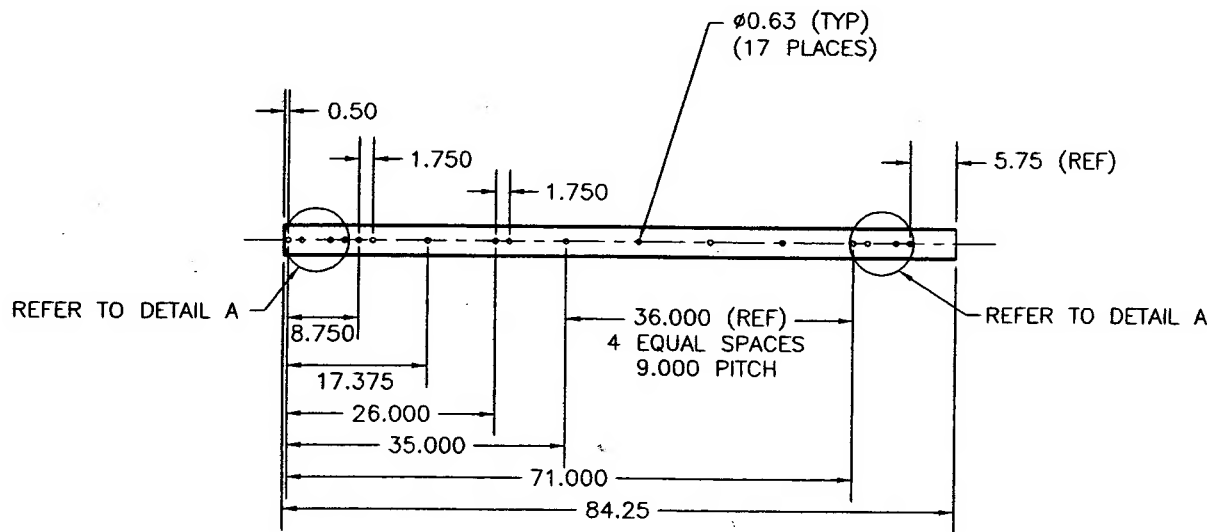
QA: N/C Closed: _____ Date: _____

DETAIL A
SCALE 5:24



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. _____



MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
48.9.11 JS



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. D
DATE	98.09.14	TITLE	204 WEB	SHEET 1 OF 1
A	96.09.16	NEW ISSUE		SCALE 1:24
B	96.10.29	5.75 WAS 0.50		
C	97.07.23	0.63 WAS 0.56		
D	98.09.14	INCORPORATED DEO 9097		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____